



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4881-041
Job Sheet 187755



Part No: D4881-041

Job Qty: 4 pcs

Part Name: 206A/B AFT Leg Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Small Fab - 2 - B4B	4 pcs	1/11/19	0.34	2.86	Small Fab - 1 - B4B				MAY 01 2019 58 9-89
						Small Fab - 2 - B4B				
						Small Fab - 3 - B4B				
						Small Fab - 4 - B4B				
						Small Fab - 5 - B4B				
						Small Fab - 6 - B4B				
						Small Fab - 7 - B4B				
120	QC 5	4 pcs	1/11/19	0.00	0.00	QC 5 - 10				MAY 02 2019 40 9-89
						QC 5 - 12				
						QC 5 - 17				
						QC 5 - 18				
						QC 5 - 19				
						QC 5 - 22				
						QC 5 - 24				
						QC 5 - 3				
						QC 5 - 38				
						QC 5 - 42				
						QC 5 - 43				
						QC 5 - 49				
						QC 5 - 51				
						QC 5 - 58				
						QC 5 - 68				
						QC 5 - 9				
						QC 5 - 50				
						QC 5 - 30				
130	Small Fab - 2 - B4B	4 pcs	1/11/19	0.00	2.86	Small Fab - 1 - B4B				MAY 02 2019 58 9-89
						Small Fab - 2 - B4B				
						Small Fab - 3 - B4B				
						Small Fab - 4 - B4B				
						Small Fab - 5 - B4B				
Plex 1/29/19 2:58 PM Dart.Hadley.Shannon										

140 QC 5	4 pcs	1/11/19	0.00 0.00	Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	MAY 13 2019 DAS
				QC 5 - 50	40
				QC 5 - 30	9-89
180 Packaging 3-1 - Stock - B4B	4 pcs	1/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	2
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
190 QC 21 - SA	4 pcs	1/11/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89 MAY 13 2019

Part Op 110 - Small Fab - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND D4885-3. DRILL OUT EACH

Descriptions: HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9973 AS PER DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Small Fab - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER DWG USE DT9974 A/R BATCH: 5080785 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG QSI 44 6.8

140 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	2/4 pcs (1 ea)	110-Small Fab - 2 - B4B	5133248
D4885-1	End Fitting	2/4 pcs (1 ea)	110-Small Fab - 2 - B4B	5183606
D4885-3	End Fitting	2/4 pcs (1 ea)	110-Small Fab - 2 - B4B	5144409
HL32PB5-12	Hi-Lok Pin	8/16 Ea (4 ea)	110-Small Fab - 2 - B4B	5131220
HL86-5	Hi-Lok Collar	8/16 pcs (4 ea)	110-Small Fab - 2 - B4B	5120513

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 2 - B4B	D4881-1	4	13	0
	D4885-1	4	9	0
	D4885-3	4	5	0
	HL32PB5-12	16	100	0
	HL86-5	16	81	0

Part Specifications

Specifications could not be found.



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	4 pcs	1/11/19	1/11/19	0.34	2.86	Small Fab-8		
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
130	Small Fab	4 pcs	1/11/19	1/11/19	0.00	2.86	Small Fab-8		
140	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
180	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		
190	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND D4885-3. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9973
AS PER DWG.
130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER
DWG USE DT9974 A/R BATCH: _____ 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG
QSI 44 6.8

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	4 Ea (1 ea)	90-Start up Operation	
D4885-1	End Fitting	4 Ea (1 ea)	90-Start up Operation	
D4885-3	End Fitting	4 Ea (1 ea)	90-Start up Operation	
HL32PB5-12	Hi-Lok Pin	16 Ea (4 ea)	90-Start up Operation	
HL86-5	Hi-Lok Collar	16 pcs (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4881-1	4	13	0
	D4885-1	4	9	0
	D4885-3	4	1	0
	HL32PB5-12	16	50	0
	HL86-5	16	101	0

Part Specifications

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Specifications could not be found.

Plex 12/17/18 7:30 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐															
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Description DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																														
Root Cause <table style="width: 100%;"> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Preservation</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Human Factors</td><td>☐</td></tr> </table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	Large ☐ Positioned Wrong n ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread <table style="width: 100%;"> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> </tr> </table>			☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up
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